

Date: Thursday, 31/07/2008 12:18:52 PM
 User: Julie Lecocq

Process Sheet

Split 260

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HELI-ACCESS STEP LH (FOLDING)
Job Number : 40857	
Estimate Number : 12567	
P.O. Number :	Part Number : D412630033
This Issue : 31/07/2008 S.O. No. :	Drawing Number : IIN D412-630
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : LARGE FAB ASSY	Drawing Revision : L
Previous Run : 40268	Material :
Written By :	Due Date : 25/08/2008 Qty: <i>2</i> Um: Each
Checked & Approved By : <i>JLD 08.8.01</i>	
Comment : Est. Rev:A New Issue 06-11-08 JLM est rev B ecn 1019, added d2807-041 EC verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------

*JLD 08.8.13*

Comment: DOCUMENT CONTROL

Photocopy bluefile & create labels per PPP D412-630-033 CHG003

oe 08/02

2.0	D2012107	Clevis
-----	----------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Clevis

Pick:

Qty	Part Number	Description
1	D2012-107.	Clevis

Batch

*B33585 x4 40274 x1**AS 08/08/06 (25)*

3.0	D2803041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2803-041	Bracket Assembly LH

Batch

*35826.x4**AS 08/08/07*

4.0	D2804041	Bracket Assembly
-----	----------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Bracket Assembly

Pick:

Qty	Part Number	Description
1	D2804-041	Bracket Assembly LH

Batch

*40278**AS 08/08/07*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

5.0 D2807041 Gas Spring Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Support Prop

Batch: 35751

JS 08/08/07 (X5)

6.0 D2813 Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Washer

Pick:

Qty Part Number Description

2 D2813 Washer

Batch

34020

JS 08/08/07 (X5)

7.0 D3562041 Step Assembly, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Step Weldment LH

Pick:

Qty Part Number Description

1 D3562-041 Step Weldment LH

Batch

41038
B41245

JS 08/09/02 (X5)

8.0 D33951 Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bushing

Pick:

Qty Part Number Description

4 D3395-1 Bushing

Batch

33578

JS 08/08/07 (X5)

9.0 AN3C21A BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

BOLT

Pick:

Qty Part Number Description

2 AN3C21A Bolt

Batch

101189

JS 08/08/07 (X5)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10.0	AN8C16	Bolt
------	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description
2	AN8C16	Bolt

Batch

106006

JS 08/08/07 (45)

11.0	AN310C8	Nut
------	---------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Nut

Pick:

Qty	Part Number	Description
2	AN310C8	Nut

Batch

M1C5426 x1 M100931 x9

JS 08/08/07 (45)

12.0	MS24665302	Cotter Pin
------	------------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Cotter Pin

Pick:

Qty	Part Number	Description
2	MS24665-302	Cotter Pin (or AN380C3-4)

Batch

M100763

JS 08/08/07 (45)

13.0	NAS1515H3	Washer
------	-----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 30.0000 Each(s)

Washer

Pick:

Qty	Part Number	Description
6	NAS1515H3	Washer

Batch

107101

JS 08/08/07 (45)

14.0	NAS1515H5L	WASHER
------	------------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

WASHER

Pick:

Qty	Part Number	Description
4	NAS1515H5L	Washer

Batch

M106541

JS 08/08/07 (45)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

NAS1515H8

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Washer

Pick:

Qty	Part Number	Description
4	NAS1515H8	Washer

Batch

106540 x11 M106575 x9

AS 08/08/07 (X5)

16.0

MS210433

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)
Nut

Pick:

Qty	Part Number	Description
4	MS21043-3	Nut

Batch

M108615 x4 M108672 x16

AS 08/08/07 (X5)

17.0

MS24693C280

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)
Screw

Pick:

Qty	Part Number	Description
2	MS24693-C280	Screw (or MS24694-C565)

Batch

M101390

AS 08/08/07 (X5)

18.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: M109929

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON

BATCH: M104251

AS 08/09/02 (2)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/02 (X2 LH)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: I

Job Number: 40857

Part Number: C

Job Number:



Seq. #:

Machine Or Operation:

Descr

20.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

21.0

D28061

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number
2 D2806-1

Description
Bushing

Batch

35638
35630

SS 08/09/02 (x2)

22.0

D28063

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bushing

Pick: Packing Kit

Qty Part Number
2 D2806-3

Description
Bushing

Batch

B36534 x6
B34019

SS 08/09/11 (x3)

SS 08/09/02 (x2)

23.0

D28105

Strut



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Strut

Pick: Packing Kit

Qty Part Number
1 D2810-5

Description
Strut

Batch

B41029 x3
41029

SS 08/09/11 (x3)

SS 08/09/02 (x2)

24.0

D33961

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Spacer

Pick: Packing Kit

Qty Part Number
2 D3396-1

Description
Spacer

Batch

34025 x6
34025

SS 08/09/11 (x3)

SS 08/09/02 (x2)

25.0

AN4C6A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty Part Number

Description

Batch

M107242 x3
M107242

SS 08/09/11 (x3)

SS 08/09/02

These kits
Pick kits
all *12** op.
in comp.

Thursday, 31/07/2008 12:18:52 PM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #: Machine Or Operation: Description :

1 AN4C6A Bolt

26.0

AN4C10A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C10A	Bolt	

Batch

M101189 x3

JS 08/09/11 (x3)

M101189

JS 08/09/02 (x2)

27.0

AN4C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN4C15A	Bolt	

Batch

M107082 x6

JS (x3)

M107082

JS 08/09/02 (x2)

28.0

AN4C7A

Eyebolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Eyebolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
1	AN4C7A	Eyebolt	

Batch

M100446 x3

JS (x3)

M100446

JS 08/09/02 (x2)

29.0

AN5C15A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s)

Bolt

Pick: Packing Kit

Qty	Part Number	Description	Batch
2	AN5C15A	Bolt	

Batch

M105125 x6

JS (x3)

M105125

JS 08/09/02 (x2)

30.0

NAS1515H4

Washer



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description	Batch
7	NAS1515H4	Washer	

Batch

M108558 x17

M108558 x17

All same batch

JS (x3) 08/09/11 (x3)

M108558

JS 08/09/02 (x2)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS STEP LH (FOLDING)

Job Number: 40857

Part Number: D412630033

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

31.0	NAS1515H5	Washer
------	-----------	--------

SEB



Comment: Qty.: 7.0000 Each(s)/Unit Total: 35.0000 Each(s)

Washer

Pick: Packing Kit

Qty	Part Number	Description
7	NAS1515H5	Washer

Batch

M108334 x21 JS (x3)
M108334 JS 08/09/02 (x2)

32.0	MS210434	Nut
------	----------	-----

SEB (x3)



Comment: Qty.: 4.0000 Each(s)/Unit Total: 20.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
4	MS21043-4	Nut

Batch

M108672 x12 JS (x3)
M108672 JS 08/09/02 (x2)

33.0	MS210435	Nut
------	----------	-----

SEB (x3)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 15.0000 Each(s)

Nut

Pick: Packing Kit

Qty	Part Number	Description
3	MS21043-5	Nut

Batch

M108583 x9 JS (x3)
M108583 JS 08/09/02 (x2)

34.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
------	-----	------------------------------------

SEB (x3)



Comment: INSPECT 100% KITS FOR COMPLETENESS

35.0	PACKAGING 1	PACKAGING RESOURCE #1
------	-------------	-----------------------

SEB (x3)



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-630-033

Location: A

PPP Rev: A

8/9/02

8/9/02

50

36.0	QC21	FINAL INSPECTION/W/O RELEASE
------	------	------------------------------

SEB (x3)



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08.09.02 2
u 08.09.12 2